

CLAIMS:

5           1.    Brazed condenser for an air conditioner comprising a  
block of tubes and fins, two collecting tubes between which said  
block is arranged, a tube-shaped collector which is mounted  
laterally on one of the collecting tubes, each collecting tube  
being a prefabricated one-piece tube, and tack weld seams by  
10   which each collecting tube is connected with the collector.

          2.    Condenser according to Claim 1, wherein the tack weld  
seams are constructed as TIG seams or laser weld seams.

15           3.    Condenser according to Claim 1, wherein at least one  
of the collecting tubes and the tube-shaped collector is provided  
with at least one plastic deformation which forms a contact  
surface for another of the collecting tubes and the tube-shaped  
collector.

20           4.    Condenser according to Claim 3, wherein the plastic  
deformation is a recess of limited axial length.

          5.    Condenser according to Claim 4, wherein an air gap is  
25   left along most of the length of the collecting tube and the  
tube-shaped collector.

5           6.    Condenser according to Claim 3, wherein a longitudinal groove is recessed into one of the tubes.

10           7.    Condenser according to Claim 3, wherein, in an area of the deformation, at least one connection opening is provided between one of the collecting tubes and a respective tube-shaped collector.

15           8.    Condenser according to Claim 1, and further comprising a coaxial tube piece by which the collector is lengthened, the coaxial tube piece being provided on its outside with a longitudinal groove forming a contact surface for the collecting tube.

20           9.    Condenser according to Claim 8, wherein the coaxial tube piece defines an extruded profile.

            10.   Condenser according to Claim 8, wherein the coaxial tube piece is provided with an internal thread for accommodating a plug.

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            11.   Condenser according to Claim 3, and further comprising a sleeve inserted into the collector and provided with an internal thread for accommodating a plug.

5           12. Condenser according to Claim 6, wherein the one of the  
tubes is the collecting tube.

13. Condenser according to Claim 2, wherein at least one  
of the collecting tubes and the tube-shaped collector is provided  
10 with at least one plastic deformation which forms a contact  
surface for another of the collecting tubes and the tube-shaped  
collector.

14. Condenser according to Claim 4, wherein, in an area of  
15 the deformation, at least one connection opening is provided  
between one of the collecting tubes and a respective tube-shaped  
collector.

15. Condenser according to Claim 5, wherein, in an area of  
20 the deformation, at least one connection opening is provided  
between one of the collecting tubes and a respective tube-shaped  
collector.

16. Condenser according to Claim 2, and further comprising  
25 a coaxial tube piece by which the collector is lengthened, the  
coaxial tube piece being provided on its outside with a  
longitudinal groove forming a contact surface for the collecting  
tube.

5           17. Condenser according to Claim 9, wherein the coaxial  
tube piece is provided with an internal thread for accommodating  
a plug.

10           18. Condenser according to Claim 4, and further comprising  
a sleeve inserted into the collector and provided with an  
internal thread for accommodating a plug.

19. A method of forming a condenser for an air conditioner  
comprising:

15           prefabricating a one-piece collecting tube,  
aligning the collecting tube and a collector with one  
another in a clamping device,  
fixedly connecting the collecting tube and the  
collector together with tack weld seams to form a collecting tube  
20 and collector assembly,  
removing the assembly from the clamping device, and  
brazing the assembly to form the condenser.

25           20. A method according to Claim 19, and further comprising  
leaving an insulating air gap along the collecting tube and the  
collector after fixedly connecting them together.